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POLY(DIALLYLAMINE)-BASED BILE ACID SEQUESTRANTS

RELATED APPLICATIONS

This application is a Continuation of U.S. Application No. 09/286,341, filed April 5, 1999, which is a Continuation of International Application No.

- 5 PCT/US97/23899, which designated the United States and was filed on December 29, 1997, published in English and which is a Continuation-in-Part of U.S. Serial No.: 08/777,408, filed December 30, 1996, now U.S. Patent No. 6,203,785. The entire teachings of the above applications are incorporated herein by reference.

BACKGROUND OF THE INVENTION

- 10 Salts of bile acids act as detergents to solubilize and, consequently, aid in the digestion of, dietary fats. Bile acids are derived from cholesterol. Following digestion, bile acids can be passively absorbed in the jejunum or reabsorbed by active transport in the ileum. Bile acids which are not reabsorbed are deconjugated and dehydroxylated by bacterial action in the distal ileum and large intestine.

- 15 Reabsorption of bile acids from the intestine conserves lipoprotein cholesterol in the bloodstream. Conversely, the blood cholesterol level can be reduced by hindering reabsorption of bile acids.

- One method of reducing the amount of bile acids that are reabsorbed is oral administration of compounds that sequester the bile acids and cannot themselves be
20 absorbed. The sequestered bile acids consequently are excreted. Serum cholesterol is then employed to produce more bile acids, thereby lowering the serum cholesterol level of the patient.

SUMMARY OF THE INVENTION

The present invention relates to a method for removing bile acids from a patient as well as certain polymers for use in the method. The method comprises the step of administering to the patient a therapeutically effective amount of a polymer

5 characterized by a diallylamine monomer wherein the amino nitrogen atom bears at least one hydrophobic substituent. The hydrophobic substituent can be a substituted or unsubstituted, straight chain or branched C₃-C₂₄-alkyl group, a substituted or unsubstituted arylalkyl group or a substituted or unsubstituted aryl group. The polymer to be administered can be homopolymer or a copolymer.

10 In one embodiment, the polymer to be administered is a crosslinked or linear poly(diallylamine) polymer wherein at least 10% of the amino nitrogen atoms are substituted by a C₃-C₂₄-alkyl group. In another embodiment, the polymer to be administered is characterized by a diallylamine monomer wherein the amino nitrogen atom bears an alkyl group which is substituted with a quaternary ammonium group.

15 The nitrogen atom of the ammonium group can bear at least one terminal hydrophobic substituent.

The polymer to be administered can comprise secondary amino groups, tertiary amino groups or quaternary ammonium groups or a combination thereof. Polymers which comprise secondary or tertiary amino groups can also be administered in the form
20 of salts of a pharmaceutically acceptable acid.

The polymer can be linear or crosslinked. In one embodiment, the polymer is crosslinked via the incorporation of a multifunctional comonomer. In another embodiment, the polymer is crosslinked via bridging groups which link amino nitrogen atoms on different polymer strands.

25 In another embodiment, the invention relates to poly(diallylamine) polymers which are useful as bile acid sequestrants. These polymers are characterized by an diallylamine monomer, or repeat unit, wherein the amino nitrogen bears an alkyl substituent which is substituted with an ammonium group. The polymer can be a homopolymer or a copolymer.

The present invention offers the advantage that both substituted and unsubstituted diallylamines are readily polymerized and crosslinked, in comparison to other amine monomers. Such polymers also provide improved efficacy over polymers utilized in prior art methods.

5 DETAILED DESCRIPTION OF THE INVENTION

The features and other details of the invention will now be more particularly described and pointed out in the claims. It will be understood that the particular embodiments of the invention are shown by way of illustration and not as limitations of the invention. The principal features of the invention can be employed in various
10 embodiments without departing from the scope of the present invention.

The present invention is based on Applicants' discovery that poly(diallylamine) polymers comprising hydrophobic groups exhibit excellent bile acid sequestration activity. The invention provides a method for removing bile acids from a patient comprising administering to the patient a therapeutically effective amount of a polymer
15 characterized by a diallylamine monomer, or repeat unit, wherein the amino nitrogen atom bears a hydrophobic substituent.

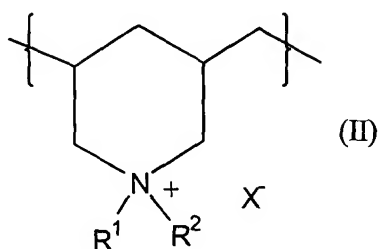
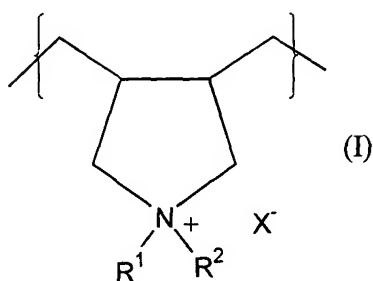
As used herein, the term "therapeutically effective amount" refers to an amount which is sufficient to remove a significant quantity of bile acids from the patient and, thus, to lower the serum cholesterol level of the patient. The patient can be an animal,
20 for example, a mammal, or a human.

A "hydrophobic substituent", as the term is used herein, is a moiety which, as a separate entity, is more soluble in octanol than water. For example, the octyl (C_8H_{17}) group is hydrophobic because its parent alkane, octane, has greater solubility in octanol than in water. The hydrophobic substituent can be a saturated or unsaturated,
25 substituted or unsubstituted hydrocarbon group. Such groups include substituted and unsubstituted, normal, branched or cyclic alkyl groups having 3 or more carbon atoms, substituted or unsubstituted arylalkyl or heteroarylalkyl groups and substituted or unsubstituted aryl or heteroaryl groups.

In one embodiment, the polymer to be administered is a poly(diallylamine) polymer characterized by a diallylamine monomer wherein the amino nitrogen atom bears at least one hydrophobic substituent selected from the group consisting of substituted or unsubstituted, normal, branched or cyclic C_3 - C_{24} -alkyl groups, such as a
 5 hexyl, heptyl, octyl, nonyl, decyl, undecyl, dodecyl, tridecyl or tetradecyl group; substituted or unsubstituted C_3 - C_{24} -alkenyl groups, such as propenyl group; substituted or unsubstituted arylalkyl groups, such as a benzyl group; and substituted or unsubstituted aryl groups, such as a phenyl or naphthyl group. Suitable alkyl
 10 substituents include halo (e.g. fluoro, chloro, bromo or iodo) groups, and alkoxy, cycloalkyl, substituted and unsubstituted, quaternary, amido, sulfone, sulfoxide, alkoxy and aryl groups. Suitable aryl and arylalkyl substituents include fluoro, chloro, bromo, iodo, amino, ammonioalkyl, alkyl, alkoxy, hydroxy, alkoxy, sulfoxide and sulfone groups.

In one embodiment, at least 10% of the amino nitrogen atoms within the
 15 polymer to be administered bear a hydrophobic substituent, such as a C_2 - C_{24} -alkyl group. Preferably at least about 20% of the amino nitrogen atoms bear a hydrophobic substituent. In other embodiments, at least about 40% of the amino nitrogen atoms can bear a hydrophobic substituent.

In general, poly(diallylamine) polymers are characterized by monomers, or
 20 repeat units, comprising five-membered rings, monomers comprising six-membered rings, or a combination thereof. In one embodiment, the polymer to be administered is characterized by an ammonium-bearing monomer of Formula I or of Formula II

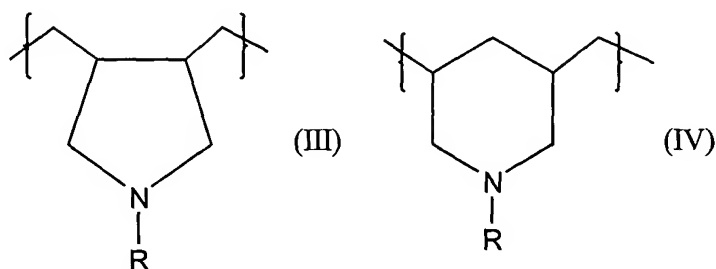


or a combination thereof, wherein R^1 is a hydrophobic substituent, as described above, and R^2 is hydrogen, methyl, or a hydrophobic substituent. In a preferred embodiment, R^1 is selected from among the octyl, decyl and dodecyl groups and R^2 is methyl.

X^- is an anion, such as the conjugate base of a pharmaceutically acceptable acid.

- 5 Such anions include chloride, citrate, tartrate, lactate, phosphate, hydrophosphate, methanesulfonate, acetate, formate, maleate, fumarate, malate, succinate, malonate, sulfate, hydrosulfate, L-glutamate, L-aspartate, pyruvate, mucate, benzoate, glucuronate, oxalate, ascorbate and acetylglycinate. In a preferred embodiment, X^- is chloride.

- In another embodiment, the polymer to be administered is characterized by an
10 amine-bearing monomeric unit of Formula III or Formula IV



or a combination thereof, wherein R is a hydrophobic substituent as previously described.

- In a preferred embodiment, the polymer to be administered comprises one or
15 more monomers of Formulas I-IV wherein at least 10%, preferably at least about 20%, of the amino nitrogen atoms bear a C_3 - C_{24} -alkyl substituent. Examples of particularly preferred C_3 - C_{24} -alkyl groups include hexyl, heptyl, octyl, nonyl, decyl, undecyl, dodecyl, tridecyl and tetradecyl groups.

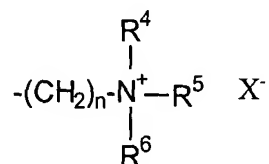
- The polymer to be administered can be a copolymer comprising one or more
20 diallylamine monomers, such as one or more monomers of Formulas I, II, III, and IV,

and at least one additional monomer. In one embodiment, the additional monomer is sulfur dioxide. In polymers comprising sulfur dioxide, the polymer backbone includes -SO₂- units between pairs of diallylamine monomers.

In a further embodiment, the invention provides a method for removing bile acids from a patient comprising the step of administering to the patient a therapeutically effective amount of a polymer characterized by a diallylamine repeat unit wherein the amino nitrogen atom bears an ammonioalkyl substituent. The invention also includes the ammonioalkyl-substituted polymers which are of use in this method.

The term "ammonioalkyl", as used herein, refers to an alkyl group which is substituted by a nitrogen atom bearing three additional substituents. Thus, the nitrogen atom is an ammonium nitrogen atom which bears an alkylene substituent, which links this atom to the diallylamine nitrogen atom, and three additional substituents selected from among hydrogen, alkyl and arylalkyl. An ammonioalkyl group will further include a negatively charged counter ion, such as a conjugate base of a pharmaceutically acceptable acid.

The diallylamine repeat unit can be, for example, of Formula I, Formula II, Formula III, or Formula IV, wherein at least one of the nitrogen substituents is an ammonioalkyl substituent. Suitable ammonioalkyl substituents are of the general formula



wherein R⁴, R⁵ and R⁶ are each, independently, a hydrogen atom or a C₁-C₂₄ alkyl group; n is an integer from 2 to about 20, preferably from 3 to about 6; and X⁻ is an anion, such as a conjugate base of a pharmaceutically acceptable acid. Preferably, at least one of R⁴, R⁵ and R⁶ is a hydrophobic group such as a C₃-C₂₄-alkyl group. More preferably, at least

one of R^4 , R^5 and R^6 is a C_6 - C_{24} -alkyl group. Suitable examples of ammonioalkyl groups include, but are not limited to, 4-(dioctylmethylammonio)butyl;

3-(dodecyldimethylammonio)propyl; 3-(octyldimethylammonio)propyl;

3-(decyldimethylammonio)propyl; 5-(dodecyldimethylammonio)pentyl;

5 3-(cyclohexyldimethylammonio)propyl; 3-(decyldimethylammonio)-2-hydroxypropyl;

3-(tridecylammonio)propyl; 3-(docosyldimethylammonio)propyl;

4-(dodecyldimethylammonio)butyl; 3-(octadecyldimethylammonio)propyl;

3-(hexyldimethylammonio)propyl; 3-(methyldioctylammonio)propyl;

3-(didecylmethylammonio)propyl; 3-(heptyldimethylammonio)propyl;

10 3-(dimethylnonylammonio)propyl; 6-(dimethylundecylammonio)hexyl;

4-(heptyldimethylammonio)butyl; 3-(dimethylundecylammonio)propyl; and

3-(tetradecyldimethylammonio)propyl.

The polymer can be a homopolymer which comprises only a monomer selected from among Formulas I-IV, above, wherein the nitrogen atom bears at least one

15 ammonioalkyl substituent. The polymer can also be a copolymer which comprises a monomer of this type and at least one additional monomer. For example, the polymer can comprise a second diallylamine monomer wherein the nitrogen atom bears a substituent selected from among hydrogen, methyl, ethyl, hydrophobic groups and ammonioalkyl groups.

20 The polymer can also comprise an additional monomer which is not a diallylamine. Suitable examples of additional polymers include substituted and unsubstituted acrylate, acrylamide, methacrylate, methacrylamide, allylamine, allyl alcohol, vinyl amine and vinyl alcohol. For example, the additional monomer can be a substituted acrylate or acrylamide which bears a hydrophobic group, such as a C_3 - C_{24} -

25 alkylacrylate or an N - C_3 - C_{24} -alkylacrylamide. The additional monomer can also be a hydrophilic monomer, such as N -(2-hydroxyethyl)acrylamide or (3-hydroxypropyl)acrylate. Also included are the multifunctional crosslinking co-monomers which are discussed in detail below.

The copolymers can have a wide range of compositions. Typically, the ammonioalkyl-substituted diallylamine monomer will constitute from about 10% to about 90% of the monomeric units composing the polymer.

The polymers of use in the present method can be linear or crosslinked. The polymer can be crosslinked, for example, by the incorporation within the polymer of a multifunctional comonomer. Suitable multifunctional co-monomers include diacrylates, triacrylates and tetraacrylates, dimethacrylates, diacrylamides, diallylacrylamide and di(methacrylamides). Specific examples include ethylene glycol diacrylate, propylene glycol diacrylate, butylene glycol diacrylate, ethylene glycol dimethacrylate, butylene glycol dimethacrylate, methylene bis(methacrylamide), ethylene bis(acrylamide), ethylene bis(methacrylamide), ethylidene bis(acrylamide), ethylidene bis(methacrylamide), pentaerythritol tetraacrylate, trimethylolpropane triacrylate, bisphenol A dimethacrylate, and bisphenol A diacrylate. Other suitable multifunctional monomers include polyvinylarenes, such as divinylbenzene. The amount of crosslinking agent is typically between 1.0% and 25% by weight relative to the weight of the polymer, preferably from about 2.5% to about 20% by weight and more preferably from about 2% to about 12% by weight.

The polymer can also be crosslinked by bridging units which link amino groups on adjacent polymer strands. Suitable bridging units include straight chain or branched, substituted or unsubstituted alkylene groups, diacylalkylene groups, diacylarene groups and alkylene bis(carbamoyl) groups. Examples of suitable bridging units include $-(CH_2)_n-$, wherein n is an integer from about 2 to about 20; $-CH_2-CH(OH)-CH_2-$; $-C(O)CH_2CH_2C(O)-$; $-CH_2-CH(OH)-O-(CH_2)_n-O-CH(OH)-CH_2-$, wherein n is 2 to about 4; $-C(O)-(C_6H_4(COOH)_2)-C(O)-$ and $-C(O)NH(CH_2)_pNHC(O)-$, wherein p is an integer from about 2 to about 20.

Advantageously, crosslinking the polymers renders the polymers non-adsorbable and stable in the patient. A "stable" polymer composition, when administered in therapeutically effective amounts, does not dissolve or otherwise decompose to form potentially harmful byproducts, and remains substantially intact.

Polymers of use in the present method are, preferably, of a molecular weight which enables them to reach and remain in the gastrointestinal tract for a sufficient period of time to bind a significant amount of one or more bile acids. The polymers should, thus, be of sufficiently high molecular weight to resist, partially or completely, absorption from the gastrointestinal tract into other regions of the body. The resulting polymer/bile salt complex should then be excreted from the body. Suitable linear (non-crosslinked) polymers have molecular weights which range from about 2,000 Daltons to about 500,000 Daltons, preferably from about 5,000 Daltons to about 150,000 Daltons. Crosslinked polymers, however, are not generally characterized by molecular weight.

10 The crosslinked polymers discussed herein should be sufficiently crosslinked to resist adsorption from the gastrointestinal tract.

The polymer network can be administered orally to a patient in a dosage of about 1 mg/kg/day to about 10 g/kg/day; the particular dosage will depend on the individual patient (e.g., the patient's weight and the extent of bile salt removal required). The polymer can be administered either in hydrated or dehydrated form, and can be flavored or added to a food or drink, if desired, to enhance patient acceptance. Additional ingredients such as other bile acid sequestrants, drugs for treating hypercholesterolemia, atherosclerosis or other related indications, or inert ingredients, such as artificial coloring agents, may be added as well.

20 Examples of suitable forms for administration include pills, tablets, capsules, and powders (i.e. for sprinkling on food). The pill, tablet, capsule or powder can be coated with a substance capable of protecting the composition from the gastric acid in the patient's stomach for a period of time sufficient for the composition to pass undisintegrated into the patient's small intestine. The polymer can be administered

25 alone or in combination with a pharmaceutically acceptable carrier, diluent or excipient substance, such as a solid, liquid or semi-solid material. Examples of suitable carriers, diluents and excipients include lactose, dextrose, sucrose, sorbitol, mannitol, starches, gum acacia, alginates, tragacanth, gelatin, calcium silicate, cellulose and others known in the art.

Polymers of use in the present method can be prepared using techniques known in the art of polymer synthesis (see for example, Shalaby *et al.*, ed., *Water-Soluble Polymers*, American Chemical Society, Washington D.C. (1991)). For example, the appropriate monomer can be polymerized by methods known in the art, for example, via
5 a free radical addition process. In this case the polymerization mixture includes a free-radical initiator, such as a free radical initiator selected from among those which are well known in the art of polymer chemistry. Suitable free-radical initiators include azobis(isobutyronitrile), azobis(4-cyanovaleric acid), azobis(amidinopropane) dihydrochloride, potassium persulfate, ammonium persulfate and potassium hydrogen
10 persulfate. The free radical initiator is preferably present in the reaction mixture in an amount ranging from about 0.1 mole percent to about 5 mole percent relative to the monomer.

The polymer can be crosslinked, for example, by including a multifunctional co-monomer as the crosslinking agent in the reaction mixture. A multifunctional co-
15 monomer can be incorporated into two or more growing polymer chains, thereby crosslinking the chains. Suitable multifunctional co-monomers include those discussed above. The amount of crosslinking agent added to the reaction mixture is, generally, between 1.0% and 25% by weight relative to the combined weight of the polymer and the crosslinking agent, and preferably from about 2.5% to about 20% by weight.

20 The multifunctional co-monomer can also take the form of a multifunctional diallylamine, such as a bis(diallylamino)alkane or a bis(diallylalkylammonio) alkane. Suitable monomers of this type include 1,10-bis(diallylmethylammonio)decane dibromide and 1,6-bis(diallylmethylammonio)hexane, each of which can be formed by the reaction of diallylmethylamine with the appropriate dibromoalkane.

25 The polymers to be administered can also be crosslinked subsequent to polymerization by reacting the polymer with one or more crosslinking agents having two or more functional groups, such as electrophilic groups, which react with amine groups to form a covalent bond. Crosslinking in this case can occur, for example, via nucleophilic attack of the polymer amino groups on the electrophilic groups. This

results in the formation of a bridging unit which links two or more amino nitrogen atoms from different polymer strands. Suitable crosslinking agents of this type include compounds having two or more groups selected from among acyl chloride, epoxide, and alkyl-X, wherein X is a suitable leaving group, such as a halo, tosyl or mesyl group.

- 5 Examples of such compounds include epichlorohydrin, succinyl dichloride, butanedioldiglycidyl ether, ethanedioldiglycidyl ether, pyromellitic dianhydride and dihaloalkanes. The crosslinking agent can also be an α,ω -alkylene diisocyanate, for example $\text{OCN}(\text{CH}_2)_p\text{NCO}$, wherein p is an integer from about 2 to about 20. The polymer can be reacted with an amount of crosslinking agent equal from about 0.5 and
- 10 20 mole percent relative to the amino groups within the polymer, depending upon the extent of crosslinking desired.

- A polymer comprising alkylated amino groups can be formed by reacting a preformed polymer with a suitable alkylating agent, or by polymerizing an alkylated monomer. Suitable alkylated monomers can be prepared by reacting diallylamine or a
- 15 diallylamine derivative, such as diallylmethylamine, with an alkylating agent. As used herein, the term "alkylating agent" refers to a compound which reacts with an amino group to form a nitrogen-carbon bond, thereby adding an alkyl or alkyl derivative substituent to the nitrogen atom. Suitable alkylating agents are compounds comprising an alkyl group or alkyl derivative which is bonded to a leaving group, such as a halo,
- 20 tosylate, mesylate or epoxy group. Examples of preferred alkylating agents include C_1 - C_{24} -alkyl halides, for example, *n*-butyl halides, *n*-hexyl halides, *n*-decyl halides, and *n*-octadecyl halides; C_2 - C_{24} -dihaloalkanes, for example, 1,10-dihalodecanes; C_1 - C_{24} -hydroxyalkyl halides, for example, 11-halo-1-undecanols; C_1 - C_{24} -arylalkyl halides, for example, benzyl halide; C_2 - C_{24} -alkylepoxy ammonium salts, for example,
- 25 glycidylpropyl-trimethylammonium salts; and C_2 - C_{24} -epoxyalkylamides, for example, N-(2,3-epoxypropyl)butyramide or N-(2,3-epoxypropyl)hexanamide. Preferred alkylating agents include halodecane, and halododecane, where in each case "halo" represents a chloro, bromo or iodo substituent.

- Diallylamine polymers having amino groups which bear quaternary ammonium-substituted alkyl groups can be prepared using alkylating agents such as (X-alkyl)ammonium salts, wherein X represents a suitable leaving group, as described above. These compounds can be prepared by the reaction of an appropriate
- 5 dihaloalkane, such as a bromochloroalkane, with a tertiary amine. Suitable alkylating agents of this type include the following:
- (4-bromobutyl)dioctylmethylammonium bromide;
 - (3-bromopropyl)dodecyldimethylammonium bromide;
 - (3-chloropropyl)dodecyldimethylammonium bromide);
 - 10 (3-bromopropyl)octyldimethylammonium bromide;
 - (3-chloropropyl)octyldimethylammonium bromide;
 - (3-iodobutyl)dioctylmethylammonium bromide;
 - (2,3-epoxypropyl)decyldimethylammonium bromide;
 - (3-chloropropyl)decyldimethylammonium bromide;
 - 15 (5-tosylpentyl)dodecyldimethylammonium bromide;
 - (6-bromohexyl)octyldimethylammonium bromide;
 - (12-bromododecyl)decyldimethylammonium bromide;
 - (3-bromopropyl)tridecylammonium bromide;
 - (3-bromopropyl)docosyldimethylammonium bromide;
 - 20 (6-bromohexyl)docosyldimethylammonium bromide;
 - (4-chlorobutyl)dodecyldimethylammonium bromide;
 - (3-chloropropyl)octadecyldimethylammonium bromide;
 - (3-chloropropyl)hexyldimethylammonium bromide;
 - (3-chloropropyl)methyldioctylammonium bromide;
 - 25 (3-chloropropyl)methyldidecylammonium bromide;
 - (3-chloropropyl)cyclohexyldimethylammonium bromide;
 - (3-bromopropyl)heptyldimethylammonium bromide;
 - (3-bromopropyl)dimethylnonylammonium bromide;
 - (6-bromohexyl)dimethylundecylammonium bromide;

(4-chlorobutyl)heptyldimethylammonium bromide;
(3-chloropropyl)dimethylundecylammonium bromide; and
(3-chloropropyl)tetradecyldimethylammonium bromide.

Each of the alkylating agents described above can also exist and be used as a salt
5 in combination with an anion other than bromide. For example, these and similar
alkylating agents can be prepared and used as salts with a wide range of anions,
including chloride, iodide, acetate, p-toluenesulfonate and methanesulfonate.

When the hydrophobic groups are added to the polymer by way of an alkylating
agent as described above, the extent of alkylation can be determined by methods which
10 are well known in the chemical arts. The increase in polymer mass due to alkylation
provides one measure of the extent of alkylation. For example, in a reaction between
poly(diallylmethylamine) and 1-bromodecane, a product/starting material mass ratio of
about 3.0, 2.0 and 1.5 represent approximately 100%, 50% and 25% alkylation,
respectively. The degree of alkylation can also be determined by elemental analysis of
15 the product polymer. In this case, the carbon/ nitrogen (C/N) mass ratio is a direct
measure of the degree of alkylation. For example, the reaction of
poly(diallylmethylamine) with 1-bromodecane yields a product with a higher C/N mass
ratio than that of the starting polymer. Product C/N mass ratios of about 6, 8.2, 10.6 and
14.6 represent, approximately, 0%, 25%, 50% and 100% alkylation, respectively.

20 The invention will now be further and specifically described by the following
examples.

EXAMPLES

Example 1- Synthesis of Diallylmethyldodecylammonium bromide

25 To a 2 L Morton flask was added diallylmethylamine (100 g), 1-bromododecane
(249 g), and tetrahydrofuran (750 mL). The mixture was heated to 65°C for 44 h, and
then allowed to cool to room temperature. The solvent was removed by rotary vacuum
evaporation to leave two layers. Diethylether (500 mL) was added and the mixture was
stirred for 1 hr. The mixture was allowed to settle and the top layer was decanted and

discarded. Additional diethylether (500 mL) was added. The mixture was stirred for 24 h, and the top layer was again decanted and discarded. The remaining oil was dried in a vacuum oven at 65°C for 4 days to yield 67 g of product.

Example 2 - Synthesis of 1,10-Bis(diallylmethylammonio)decane dibromide

5 To a 1 L Morton flask was added diallylmethylamine (86.1 g),
1,10-dibromodecane (112 g), and methanol (100 mL). The mixture was heated to 65° C
for 24 h, and then allowed to cool to room temperature. The solvent was removed by
rotary vacuum evaporation. Diethylether (400 mL) was added and the mixture was
stirred for 1 hr. The mixture was allowed to settle and the top layer was decanted and
10 discarded. The remaining oil was dried by rotary vacuum evaporation to yield 215 g of
product.

Example 3 - Synthesis of 1,6-Bis(diallylmethylammonio)hexane dibromide

 To a 1 L Morton flask was added diallylmethylamine (74.6 g),
1,6-dibromohexane (77 g), and methanol (100 mL). The mixture was heated to 65° C
15 for 17 h, and then allowed to cool to room temperature. Diethylether (300 mL) was
added and the mixture was stirred for 1 hr. The solid was collected by filtration and
resuspended in diethylether (200 mL). The mixture was stirred for 1 hr, and the solid
again collected by filtration. The solid was then dried in a vacuum oven at 50° C for 3
days to yield 136 g of product.

20 Example 4 - Synthesis of Poly[1,10-bis(diallylmethylammonio)-decane dibromide]

 To a 250-mL, round bottom flask was added 1,10-bis(diallylmethylammonio)
decane dibromide (20 g) and water (40 g). Azobisisobutyramidine dihydrochloride
(0.5 mL of a 50% aqueous solution) was added and nitrogen was bubbled through the
mixture for 1 hr. The mixture was then heated to 60° C with stirring for 4 hr, at which
25 time additional azobisisobutyramidine dihydrochloride (0.5 mL of a 50% aqueous
solution) was added.

After 18 hr the solution was allowed to cool to room temperature. The resulting gel was removed and ground in a blender with water (500 mL). The solid was collected by centrifugation and resuspended in methanol (500 mL). After stirring for 1 hr, the solid was collected by filtration and resuspended in aqueous NaCl (500 mL of 1.5 M solution). After again stirring for 1 hr, the solid was collected by filtration. The aqueous NaCl rinse was repeated twice more, and the solid was rinsed with water until the conductivity of the rinse reached 0.3 mS/cm. The solid was dried in a forced air at 60° C to yield 10.0 g of product.

Example 5 - Synthesis of Copoly[1,10-bis(diallylmethylammonio)decane dibromide/
diallylmethyldodecylammonium bromide]

To a 500-mL round bottom flask was added 1,10-bis(diallylmethylammonio)decane dibromide (21.1 g), diallylmethyldodecylammonium bromide (21.1 g), and water (52 g). Azobisisobutyramidine dihydrochloride (1 mL of a 50% aqueous solution) was added and nitrogen was bubbled through the mixture for 1 hr. The mixture was then heated to 60° C with stirring for 18 hr. The resulting gel was allowed to cool to room temperature. The gel was removed and ground in a blender with water (250 mL). The solid was collected by filtration and resuspended in methanol (250 mL). The solid was collected by filtration and resuspended in methanol (250 mL). After stirring for 1 hr, the solid was collected by filtration and resuspended in aqueous NaCl (250 mL of 1.5 M solution). After again stirring for 1 hr, the solid was collected by filtration. The aqueous NaCl rinse was repeated twice more, and the solid was rinsed with water until the conductivity of the rinse reached 0.08 mS/cm. The solid was dried in a forced-air oven at 60° C to yield 17.6 g of product.

Example 6 - Synthesis of Epichlorohydrin Crosslinked Poly(diallylmethylamine)

A crosslinked gel of N-methyl-N,N-diallylamine polymer was prepared by reacting the corresponding linear soluble polymer with epichlorohydrin. The starting material, poly(diallylmethylamine) was obtained in the form of its hydrochloride salt

from Nitto Boseki Co. The polymer was obtained as a 60% aqueous solution (PAS-M-1, Lot # 51017). The chemical process to obtain insoluble gels of this polymer involved partial neutralization of the amine hydrochloride polymer with a base followed by treatment with a predetermined amount of epichlorohydrin at room temperature.

- 5 Experimental details to obtain a typical crosslinked gel of poly(diallylmethylamine hydrochloride) are given below.

83 g of the polymer solution was diluted with 170 mL deionized water. While stirring, 6.8 g NaOH was added to the polymer solution. The reaction mixture was allowed to stir until all NaOH had dissolved. When the temperature of the solution had
10 dropped to below 30° C, epichlorohydrin (1.2 mL) was added and stirring continued. The reaction medium slowly became viscous and after about 80 minutes, had gelled and the stirring was stopped. The polymer gel was left at room temperature for an additional 60 hr. The polymer slab was broken into smaller pieces and dispersed in 400 mL deionized water. The resulting suspension was stirred for 2 hr and then filtered.
15 The swollen polymer particles were resuspended in 600 mL deionized water, stirred for 45 minutes and collected by filtration. The process was repeated with 800 mL water and 1 hr stirring. After filtration, the filtrate showed a conductivity of 4 mS/cm. The filtered polymer (swollen gel) was dried in a forced air oven at 60° C to yield 42 g of product.

- 20 Example 7 - Alkylation of Crosslinked Poly(diallylmethylamine) with 1-bromodecane

25 g of the ground polymer (Example 6) taken in a 1 liter 3-necked round bottom flask was suspended in 250 mL deionized water. The polymer swelled significantly and was stirred with a mechanical stirrer. To this swollen gel was added 100 g 1-bromodecane dissolved in 250 mL ethanol and the reaction mixture was stirred
25 for 10 minutes. Subsequently, 5 g of 50% aqueous sodium hydroxide was added and the reaction mixture was stirred at room temperature for 40 minutes followed by heating to 75° C for 1 hr. 2 g NaOH solution was then added followed by additional 2 g of NaOH solution after another 1.5 hr (the base addition was such as to maintain the pH

between 10 and 12). The reaction mixture was stirred at 75° C for an additional 18 hours, after which time heating was discontinued. After cooling to 30° C, 5 mL concentrated HCl was added and stirring was continued for 30 minutes. The pH of the medium dropped to 1.8. The polymer was filtered and washed with 500 mL deionized water followed by 500 mL methanol. Polymer particles were suspended in 600 mL methanol and stirred for 40 minutes. After removing the solvent by filtration, the polymer was suspended in 500 mL of 2 M NaCl solution and stirred for 40 minutes. The polymer was filtered and this process of NaCl treatment was repeated two more times. The filtered polymer cake was washed with 500 mL deionized water and suspended in 500 mL deionized water. After stirring for 30 minutes the polymer was filtered and resuspended in 700 mL deionized water and stirred for 30 minutes. Concentrated HCl (2 mL) was added to the suspension and the mixture was stirred for 15 minutes. The pH of the suspension was found to be 2.25. After stirring for an additional 20 minutes, the polymer was filtered and dried at 60° C in a forced air oven, yielding 54.6 g of the alkylated polymer as a light yellow solid. The polymer was ground and passed through a 140 mesh sieve.

Example 8 - Alkylation of Crosslinked poly(diallylmethylamine) with
1-bromododecane

10 g of the ground polymer (Example 6) was suspended in 100 mL deionized water in a 500 mL 3-necked round-bottomed flask. The polymer swelled significantly and was stirred with a mechanical stirrer. To this swollen gel, 28 g 1-bromododecane dissolved in 100 mL ethanol was added and the reaction mixture was stirred for 10 minutes. 2 g of 50% aqueous sodium hydroxide was then added and the reaction mixture was stirred at room temperature for 40 minutes, followed by heating to 75° C for 1 hr. 1 g NaOH solution was then added followed by an additional 1 g of NaOH solution after another 1.5 hr (the base addition was such as to maintain the pH between 10 and 12). The reaction mixture was stirred at 75° C for an additional 18 h after which time the heating discontinued. After cooling to 30° C, concentrated HCl (2 mL) was

added and the mixture was stirred for 30 minutes. The polymer was filtered and washed with 500 mL deionized water followed by 500 mL methanol. Polymer particles were suspended in 300 mL methanol and stirred for 40 minutes. After removing the solvent by filtration, the polymer was suspended in 500 mL 2M NaCl solution and stirred for 40
5 minutes. It was filtered and this process of NaCl treatment was repeated two more times. The filtered polymer cake was washed with 500 mL deionized water and suspended in 500 mL deionized water. After stirring for 30 minutes the polymer was filtered and resuspended in 500 mL deionized water and stirred for 30 minutes. Concentrated HCl (2 mL) was added to the suspension and the mixture was stirred for
10 15 minutes. The pH of the suspension was found to be 2.2. After stirring for an additional 20 minutes, the polymer was filtered and dried at 60° C in a forced air oven, yielding 18 g of the alkylated polymer as a pale white solid. The polymer was ground and passed through a 140 mesh sieve.

Example 9 - Preparation of (3-chloropropyl)-dodecyldimethylammonium bromide

15 A two-liter, 3-necked, round-bottomed flask equipped with an air condenser and a magnetic stirring plate was charged with N,N-dimethyldodecylamine (297.24 grams, 1.40 moles), 1-bromo-3-chloropropane (220.44 grams, 1.40 moles) and methanol (250 mL). Reaction was maintained at 65° C for 24 hours. Methanol was removed by rotary evaporation under reduced pressure to yield a brown sludge. To the sludge was
20 added methyl-tert-butylether (2 liters) causing a white solid to form. The mixture was stirred for two hours and a semi-crystalline, white particulate was collected by vacuum filtration. The particulate was dried in a vacuum oven at 35° C for 24 hours. Yield 228.2 grams (0.61 moles, 44%).

(4-Chlorobutyl)dodecyldimethylammonium bromide and (6-chlorohexyl)
25 dodecyldimethylammonium bromide can be prepared by a similar process using the appropriate bromochloroalkane and dodecyldimethylamine.

Example 10 - Alkylation of Crosslinked Poly(diallylmethylamine) with
(3-chloropropyl)dimethyldodecylammonium bromide

A mixture of 11 g crosslinked polymer gel (Example 6) and 74 g (3-chloropropyl)-dimethyldodecylammonium bromide was dispersed in 250 mL deionized water and heated to 75° C with stirring. After stirring at 75° C for 15 minutes, 2 g of a 50% aqueous NaOH solution was added to the reaction mixture. After 2 hr, 1 g of NaOH solution was added followed by an additional 1 g after another 1 hr and the mixture was stirred at 75° C for 23 hr. The reaction mixture was then allowed to cool. After cooling to 30° C, 3 mL concentrated HCl was added and the mixture was stirred for 30 minutes. The polymer was filtered and washed with 200 mL methanol. The filtered polymer particles were dispersed in 400 mL methanol and stirred for 45 minutes and filtered. This process was repeated one more time, then the filtered polymer was suspended in 500 mL 2M NaCl solution, stirred for 45 minutes and filtered. This process of NaCl treatment was repeated twice and the filtered polymer was suspended in 500 mL deionized water. The mixture was stirred for 45 minutes, filtered, resuspended in 400 mL deionized water and stirred for an additional 40 minutes. To this suspension, 1 mL concentrated HCl was added and the mixture was stirred for 20 minutes. The polymer was filtered and dried in a forced air oven at 60° C, yielding 29 g of alkylated polymer as a light yellow solid which was ground and passed through a 140 mesh sieve.

Example 11 - Alkylation of Crosslinked Poly(diallylmethylamine) with (4-chlorobutyl)-dimethyldodecylammonium bromide

A mixture of 10 g 3% crosslinked polymer gel (Example 6) and 76 g (4-chlorobutyl)dimethyldodecyl-ammonium bromide was dispersed in 250 mL deionized water and heated to 70°C with stirring for 15 minutes. 2 g 50% aqueous solution of NaOH was then added to the reaction mixture. After 2 hr, 1 g NaOH solution was added followed by additional 1 g after another 2 hr. The reaction mixture was then stirred at 70° C for 20 hours. 1 g NaOH was then added and the reaction

mixture was kept at 70° C. After 20 hr heating, 1 g NaOH solution was added and the reaction mixture was kept at 70° C with stirring for 2 hr. After cooling to 30° C, 2 mL of concentrated HCl was added and the mixture was stirred for 20 minutes. The polymer was filtered and washed successively with 200 mL deionized water and
5 200 mL methanol. The filtered polymer particles were then dispersed in 500 mL methanol, stirred for 30 minutes, and filtered. This process was repeated an additional time and the filtered polymer was suspended in 400 mL 2M NaCl solution, stirred for 45 minutes and filtered. After repeating NaCl treatment twice, the filtered polymer was suspended in 400 mL deionized water. The mixture was stirred for 30 minutes, filtered,
10 resuspended in 400 mL deionized water and stirred for an additional 40 minutes. To this polymer suspension, 1 mL concentrated. HCl was added and the mixture was stirred for 20 minutes. The polymer was then filtered and dried in a forced air oven at 60° C, yielding 27 g alkylated polymer as a light yellow solid which was ground and passed through a 140 mesh sieve.

15 Example 12 - Alkylation of Crosslinked Poly(diallylmethylamine) with
(6-chlorohexyl)-dimethyloctylammonium bromide

A mixture of 10 g 3% crosslinked polymer gel (Example 6) and 71 g (6-chlorohexyl)dimethyldodecyl-ammonium bromide was dispersed in 200 mL deionized water and heated to 75° C with stirring for 15 minutes. 2 g 50% aqueous
20 solution of NaOH was then added to the reaction mixture. After 3 hr, 1 g NaOH solution was added. After 2.5 hr an additional 1 g of NaOH solution was added and the reaction mixture was stirred at 75° C for 22 hr. 0.5 g NaOH was then added and heating was continued for an additional 2 hr. After cooling to 30° C, 2 mL concentrated HCl was added and the mixture was stirred for 15 minutes. The polymer was then filtered
25 and washed successively with 200 mL deionized water and 200 mL methanol. The filtered polymer particles were then dispersed in 500 mL methanol, stirred for 30 minutes and filtered. This process was repeated two times, then the filtered polymer was suspended in 400 mL 2M NaCl solution, stirred for 45 minutes and filtered. After

repeating the NaCl treatment twice, the filtered polymer was suspended in 400 mL deionized water. The mixture was stirred for 30 minutes, filtered, and resuspended in 400 mL deionized water and stirred for an additional 40 minutes. To this polymer suspension was added 1 mL concentrated HCl and the mixture was stirred for 20 minutes. The polymer was filtered and dried in a forced air oven at 60° C, yielding 25 g alkylated polymer as a white solid, which was ground and passed through a 140 mesh sieve.

Example 13 - Alkylation of Crosslinked Poly(diallylmethylamine) with 1-bromodecane

This example illustrates alkylation of the 4.5% crosslinked poly(diallylmethylamine) with different amounts of 1-bromodecane to obtain quaternized polyamines bearing varying amounts of hydrophobic groups. For this purpose, the polymer was treated with varying mole fractions of 1-bromodecane (1.0, 0.75, 0.50, 0.25 and 0.10). Table 1 summarizes amounts of 1-bromoalkane used to obtain polymers of varying degree of alkylation and the yield of alkylated polymer per gram of the 4.5 % crosslinked poly (diallylmethylamine) (Example 2). This g/g yield is a measure of the degree of alkylation of the polymer.

10 g of the 4.5% crosslinked poly(diallylmethyl-amine) was suspended in 150 mL deionized water. While stirring, 2 g 50% aqueous NaOH solution was added to the polymer and the suspension was stirred for 15 minutes. At this time an ethanol solution of 1-bromodecane (2.5 mL ethanol/g 1-bromodecane) was added and the reaction mixture was heated to 75° C with stirring. After 2 hr, 1 g NaOH was added, followed by an additional 1 g of NaOH after another 2 hr. The reaction mixture was stirred at 75° C for 18 hours and was then allowed to cool. After cooling to 30° C, 2 mL concentrated HCl was added and the mixture was stirred for 15 minutes. The polymer was filtered and washed with 200 mL deionized water and 200 mL methanol for 30 minutes and filtered. This process was repeated twice and the filtered polymer was suspended in 400 mL of 2M NaCl solution, stirred for 45 minutes and filtered. After repeating the NaCl

treatment twice, the filtered polymer was suspended in 400 mL deionized water. The mixture was stirred for an additional 30 minutes, filtered, resuspended in 400 mL deionized water and stirred for an additional 40 minutes. To this polymer suspension was added 1 mL concentrated HCl and the mixture was stirred for 20 minutes. The polymer was filtered, dried in a forced air oven at 60° C, ground and passed through a 140 mesh sieve. Yield of the polymers for different amounts of the 1-bromodecane used are summarized in Table 1. The calculation of % alkylation assumed protonation of 50% of the amino nitrogen atoms.

Table 1. Results of the alkylation of 4.5 % crosslinked poly(diallylmethylamine) with varying amounts of 1-bromodecane ($C_{10}H_{21}Br$) ("ratio" = ratio of 1-bromodecane to polymer amino groups (mole/mole)).

Polymer Used (g)	$C_{10}H_{21}Br$ used (g)	Ratio	product yield (g)	product/starting polymer (g/g)	% alkylation
10.0	17.0	1.0	17	1.7	35
10.0	12.5	0.75	16.8	1.68	34
10.0	8.0	0.50	14.3	1.43	22
10.0	4.25	0.25	11.8	1.18	9
10.0	1.70	0.10	10.6	1.06	3

Example 14 - Alkylation of Crosslinked Poly(diallylmethylamine) with 1-bromotetradecane

10 g of 4.5% crosslinked polydiallylmethylamine (Example 6) was suspended in 100 mL in a 500 mL 3-necked round-bottomed flask of deionized water. The polymer swelled significantly and was stirred with a mechanical stirrer. To this swollen gel, was added 32 g 1-bromotetradecane dissolved in 100 mL ethanol, and the reaction mixture was stirred for 10 minutes. 2 g 50% aqueous sodium hydroxide was then added and the

reaction mixture was stirred at room temperature for 40 minutes followed by heating to 75° C for 1 hr. 1 g NaOH solution was then added followed by an additional 1 g of NaOH solution after another 1.5 hr (the base addition was such as to maintain the pH between 10 to 12). The reaction mixture was stirred at 75° C for an additional 18 hours
5 after which time the heating was discontinued. After cooling to 30° C, 2 mL concentrated HCl was added and the mixture was stirred for 30 minutes. The polymer was filtered and washed with 500 mL deionized water followed by 500 mL methanol. Polymer particles were suspended in 300 mL methanol and stirred for 40 minutes. After removing the solvent by filtration, the polymer was suspended in 500 mL of 2M NaCl
10 solution and stirred for an additional 40 minutes. The polymer was filtered and this process of NaCl treatment was repeated twice. The filtered polymer cake was then washed with 500 mL deionized water and suspended in 500 mL deionized water. After stirring for 30 minutes the polymer was filtered and resuspended in 500 mL deionized water and the suspension was stirred for 30 minutes. 1 mL concentrated HCl was then
15 added to the suspension, which was stirred for another 55 minutes. The polymer was then filtered and dried at 60° C in a forced air oven, yielding 22 g of the alkylated polymer. The polymer was ground and passed through a 140 mesh sieve.

Example 15 - Alkylation of Crosslinked Poly(diallylmethylamine) with 1-Bromooctane
10 g of 4.5% crosslinked poly(diallylmethylamine) (Example 7) was suspended
20 in 100 mL in a 500 mL 3-necked round bottom flask of deionized water. The polymer swelled significantly and was stirred with a mechanical stirrer. To this swollen gel, was added 23 g 1-bromooctane dissolved in 100 mL ethanol and the reaction mixture was stirred for 10 minutes. 2 g of 50% aqueous sodium hydroxide was then added and the reaction mixture was stirred at room temperature for 40 minutes, followed by heating to
25 75° C for 1 hr. 1 g NaOH solution was then added, followed by an additional 1 g of NaOH solution after another 1.5 hr. The reaction mixture was allowed to stir at 75° C for an additional 18 hours after which time the heating was discontinued. After cooling

to 30° C, 2 mL concentrated HCl was added and stirring was continued for 30 minutes. The polymer was filtered and washed with 500 mL deionized water followed by 500 mL methanol. Polymer particles were suspended in 300 mL methanol and stirred for 40 minutes. After removing the solvent by filtration, the polymer was suspended in 500 mL 2M NaCl solution and the suspension was stirred for 40 minutes. The polymer was filtered and this process of NaCl treatment was repeated twice. The filtered polymer cake was washed with 500 mL deionized water and suspended in 500 mL deionized water. After stirring for 30 minutes the polymer was filtered, resuspended in 500 mL deionized water, and stirred for 30 minutes. 1 mL concentrated HCl was added to the suspension and stirred for 35 minutes. The polymer was then filtered and dried at 60° C in a forced air oven, yielding 15.8 g of the alkylated polymer. The polymer was ground and passed through a 140 mesh sieve.

Example 16 - Alkylation of Crosslinked Poly(diallylmethylamine) with 1-Bromohexane
10 g of 4.5% crosslinked poly(diallylmethylamine) (Example 6) taken in a 500 mL 3-necked round bottom flask was suspended in 100 mL deionized water. The polymer swelled significantly and was stirred with a mechanical stirrer. To this swollen gel was added, 19 g 1-bromodecane dissolved in 100 mL ethanol was added and the reaction mixture was stirred for 10 minutes. 2 g of 50% aqueous sodium hydroxide was then added and the reaction mixture was stirred at room temperature for 40 minutes, followed by heating to 75° C for 1 hr. 1 g NaOH solution was then added followed by an additional 1 g of NaOH solution after another 1.5 hr. The reaction mixture was stirred at 75° C for an additional 18 hours after which time the heating was discontinued. After cooling to 30° C, 2 mL concentrated HCl was added and the mixture was stirred for 30 minutes. The pH of the medium at this point was 2.0. The polymer was filtered and washed with 500 mL deionized water followed by 500 mL methanol. The polymer particles were suspended in 300 mL methanol and stirred for 40 minutes. After removing the solvent by filtration, the polymer was suspended in

500 mL of 2 M NaCl solution and the suspension was stirred for 40 minutes. The polymer was filtered and this process of NaCl treatment was repeated twice. The filtered polymer cake was washed with 500 mL deionized water and suspended in 500 mL deionized water. After stirring for 30 minutes, the polymer was filtered, 5 resuspended in 500 mL deionized water and stirred for 30 minutes. 1 mL concentrated HCl was added to the suspension, which was stirred for 35 minutes. The polymer was then filtered and dried at 60° C in a forced air oven, yielding 13.7 g of the alkylated polymer. The polymer was ground and passed through a 140 mesh sieve.

Example 17 - Synthesis of Quaternized N-alkyl diallylmethylammonium Salts.

10 Synthesis of N-decyldiallylmethylammonium bromide.

Diallylmethylamine (33.3 g) and 1-bromodecane (66.6 g) were dissolved in 100 mL methanol and the reaction mixture was stirred at 65° C for 48 hours. After cooling to room temperature, the methanol was removed under reduced pressure. The residual viscous oil was precipitated into 800 mL dry ether with rapid stirring. The 15 ether layer was decanted and the residue was again treated with 500 mL dry ether. After stirring for 15 minutes the solvent was removed and the oily residue was dried under vacuum at 35° C for 48 hours, yielding 78 g of the product.

Synthesis of N-(N,N-dimethyl-N-dodecylammonio) propyldiallylmethylammonium chloride bromide

20 A mixture of 22 g diallylmethylamine and 74 g 3-chloropropyl-dodecyl-dimethylammonium bromide were dissolved in 100 mL methanol and the reaction mixture was stirred at 65° C for 48 hours. The progress of the reaction was monitored by the disappearance of the diallylmethylamine by thin layer chromatography (TLC). After cooling to room temperature, the solvent was removed under reduced pressure. The 25 residual viscous oil was precipitated into 800 mL dry ether with rapid stirring. The ether layer was decanted and the residue was again treated with 500 mL dry ether. After

stirring for 15 minutes the solvent was removed and the oily residue was dried under vacuum at 35° C for 48 hours, yielding 70 g of the product.

Synthesis of N-(N,N-dimethyl-N-dodecylammonio)butyl- diallylmethylammonium chloride bromide.

- 5 A mixture of 22 g diallylmethylamine and 75 g 4-chlorobutyldimethyldodecyl-
ammonium bromide were dissolved in 100 mL methanol and the reaction mixture was
stirred at 65° C for 48 hours. The progress of the reaction was monitored by the
disappearance of the diallylmethylamine by thin layer chromatography (TLC). After
cooling to room temperature, the solvent was removed under reduced pressure. The
10 residual viscous oil was precipitated into 800 mL dry ether with rapid stirring. The
ether layer was decanted and the residue was again treated with 500 mL dry ether. After
stirring for 15 minutes the solvent was removed and the oily residue was dried under
vacuum at 35° C for 48 hours, yielding 65 g of the product.

- Synthesis of poly(N-decyldiallylmethylammonium bromide) crosslinked with
15 methylenebis(acrylamide)
25 25 g N-decyldiallylmethylammonium bromide, 3 g N,N-methylenebis-
acrylamide and 300 mg 2,2'-azobis(2-amidinopropane)dihydrochloride were dissolved
in 100 mL deionized water. The solution was bubbled with a slow stream of nitrogen
for 30 minutes then heated to 70° C with stirring. After 2 hr, the reaction mixture
20 turned cloudy with formation of a suspension. The mixture was kept at 70° C for a
period of 18 hours and then allowed to cool. The suspension was centrifuged. The
residue dispersed in 200 mL deionized water, stirred for 30 minutes and centrifuged.
After removal of the supernatant, the residue was suspended in 200 mL methanol,
stirred for 30 minutes and centrifuged. The residue was suspended in 300 mL methanol
25 and the suspension was refluxed for 1 hr. After cooling to room temperature, the
suspension was filtered and the white solid was dried at 60° C for 24 hr to yield 10 g of
the polymer. The polymer was ground and passed through 140 mesh sieve.

Example 19 - Synthesis of Crosslinked Poly(diallylammonium chloride-co-sulfur dioxide) Copolymer

111 g of a 20% solution of copoly(diallylmethyl-ammonium chloride-co-sulfur dioxide) (PAS-92, obtained from Nitto Boseki Co., Japan) was treated with 2.2 g solid NaOH with stirring. The solution turned cloudy and phase separation occurred. The bottom viscous layer was separated from the top layer and the former was diluted with 20 mL water. To this solution, 0.6 mL epichlorohydrin was added and the reaction mixture was allowed to stir for 2 hr. The reaction medium slowly became increasingly viscous and was left at room temperature for 48 hours, during which period it turned into a gel. The resulting polymer gel was broken into smaller pieces and was dispersed in 1 liter deionized water. The suspension was stirred for 1 hr and filtered. The swollen polymer particles were resuspended in 800 mL deionized water and stirred for 1.5 hr. The polymer particles were then filtered and dried in a forced air oven at 60° C to yield 16 g of polymer. The dried polymer was ground and passed through a 10 mesh sieve.

Example 20 - Alkylation of 6% Crosslinked Copoly(diallylmethylamine-co-sulfur dioxide) with 1-bromodecane

The polymer (5 g) of Example 20 was placed in a 500 mL 3-necked round bottom flask and suspended in 100 mL deionized water. The polymer swelled significantly and was stirred with a mechanical stirrer. To this swollen gel, a solution of 18 g 1-bromodecane in 100 mL ethanol was added and the reaction mixture stirred for 10 minutes. Subsequently, 2 g 50% aqueous sodium hydroxide was added and the reaction mixture was stirred at room temperature for 30 minutes followed by heating to 75° C. After 1 hr, 0.5 g NaOH solution was added followed by an additional 0.5 g of NaOH solution after another 1.5 hr. The reaction mixture was allowed to stir at 75° C for an additional 18 hr after which time the heating was discontinued. After cooling to 30° C, 2 mL concentrated HCl was added and the mixture was stirred for 30 minutes. The pH of the medium dropped to 1.2. The polymer was filtered off and washed with 500 mL deionized water and 500 mL methanol. Polymer particles were suspended in

300 mL methanol and stirred for 40 minutes. After removing the solvent by filtration, the polymer was suspended in 500 mL 2M NaCl solution and stirred for 40 minutes. The suspension was filtered and the NaCl treatment was repeated two more times. The filtered polymer cake was washed with 500 mL deionized water and suspended in
5 500 mL deionized water. After stirring for 30 minutes it was filtered and resuspended in 500 mL deionized water and stirred for 30 minutes. 1 mL of concentrated HCl was added to the suspension and the suspension was stirred for 35 minutes. The polymer was then filtered and dried at 60° C in a forced air oven, yielding 9.1 g of the alkylated polymer. The polymer was ground and passed through a 140 mesh sieve.

10 Example 21 - Alkylation of Crosslinked Copoly(diallylmethylamine-co-sulfur dioxide)
with (3-chloropropyl)-dimethyldodecylammonium bromide

To a mixture of 5 g of the polymer of Example 20 and 30 g
(3-chloropropyl)dimethyldodecylammonium bromide in a 500 mL 3-necked round
bottom flask was added 150 mL deionized water. The resulting mixture was stirred
15 with a mechanical stirrer. 2 g of 50% aqueous sodium hydroxide was added and the
reaction mixture was stirred at room temperature for 30 minutes, followed by heating to
75° C for 1 hr. NaOH solution (0.5 g) was added, followed by an additional 0.5 g of
NaOH solution after another 1.5 hr. The reaction mixture was allowed to stir at 75° C
for an additional 18 hr after which time the heating was discontinued. After cooling to
20 30° C, 2 mL concentrated HCl was added and the mixture was stirred for 30 minutes.
The pH of the medium dropped to 2.8. The polymer was filtered off and washed with
500 mL deionized water and 500 mL methanol. Polymer particles were then suspended
in 300 mL methanol and the suspension was stirred for 40 minutes. The polymer was
isolated by filtration and then suspended in 500 mL 2M NaCl solution. The suspension
25 was stirred for 40 minutes. The polymer was filtered off and this NaCl treatment was
repeated two more times. The filtered polymer cake was washed with 500 mL
deionized water and then suspended in 500 mL deionized water. After stirring for 30
minutes the polymer was filtered off and resuspended in 500 mL deionized water. The

suspension was stirred for 30 minutes. 1 mL concentrated HCl was added to the suspension and the suspension was stirred for 35 minutes. The polymer was then filtered and dried at 60° C in a forced air oven, yielding 11.4 g of the alkylated polymer. The polymer was ground and passed through a 140 mesh sieve.

5 Example 22 - Preparation of Poly(diallylammonium chloride)

100 g diallylamine and 100 mL deionized water were placed in a 1 liter beaker and the mixture was allowed to stir. To this stirred mixture, 37% aqueous HCl was added slowly with concurrent measurement of pH. When the pH of the solution dropped below 7, addition of acid stopped. The solution was extracted with 600 mL diethyl ether. To the aqueous solution, 3 g 2,2'-azobis(2-amidinopropane) dihydrochloride was added and the solution was bubbled with nitrogen gas for 45 minutes. The solution was then heated to 70° C for 48 hr, after which time the reaction mixture has turned viscous. Heating was discontinued and, after cooling to room temperature, 315 g of polymer solution was obtained.

15 Example 23 - Synthesis of insoluble crosslinked polydiallylamine

The polydiallylammonium chloride solution of Example 23 (150 g) was diluted with 50 mL deionized water. Solid NaOH (6.75 g) was added to the polymer solution with stirring. The reaction mixture was stirred until the NaOH has dissolved and temperature of the solution had dropped to below 30° C. To this partially neutralized polymer solution, epichlorohydrin (1.2 mL) was added and stirring was continued. The reaction medium slowly became increasingly viscous and after about 50 minutes it gelled and the stirring stopped. This gelled polymer was left at room temperature for an additional 48 hr to yield a semi-brittle polymer slab. The polymer slab was broken into smaller pieces and was dispersed in 1 L deionized water. The resulting suspension was stirred for 1.5 hr and then filtered. The swollen polymer particles were resuspended in 1 L deionized water and the suspension was stirred for 40 minutes. The polymer particles were filtered off and dried in a forced air oven at 60° C to yield 56 g of pale

white solid polymer. The dried polymer was ground and passed through a 10 mesh sieve.

Example 24 - Alkylation of Crosslinked Polydiallylamine with 1-bromododecane

The ground polymer of Example 23 (5 g) was placed in a 500 mL 3-necked
5 round-bottomed flask and suspended in 100 mL deionized water and the suspension was stirred with a mechanical stirrer. To this swollen gel, a solution of 15 g 1-bromododecane in 100 mL ethanol was added and the reaction mixture was stirred for 10 minutes. 2 g 50% aqueous sodium hydroxide was then added and the reaction mixture was stirred at room temperature for 40 minutes followed by heating to 75° C. Subsequently, an
10 additional 4 g 50% NaOH was added in a 1 g batch at an interval of 1.5 hr (the base addition maintained a pH between 10 to 12). The reaction mixture was allowed to stir at 75° C for a total period of 20 hr. After cooling to 30° C, 2 mL concentrated HCl was added and the mixture was stirred for 30 minutes. The polymer was filtered off and washed with 500 mL deionized water and 500 mL methanol. The filtered polymer
15 particles were slurried in methanol (400 mL), stirred for 40 minutes and reisolated by filtration. This process was then repeated. The polymer was suspended in 500 mL 2M NaCl solution and the suspension was stirred for 40 minutes. The polymer was filtered off and this NaCl treatment was repeated two more times. The filtered polymer cake was washed with 500 mL deionized water and suspended in 500 mL deionized water. After
20 stirring the suspension for 30 minutes, the polymer was filtered off and resuspended in 500 mL deionized water. The resulting suspension was stirred for 30 minutes. 1 mL concentrated HCl was added to the suspension, which was then stirred for 35 minutes. The pH of the suspension was found to be 2.2. The polymer was then filtered off and dried at 60° C in a forced air oven, yielding 13.3 g of the alkylated polymer as a pale
25 white solid. The polymer was ground and passed through a 140 mesh sieve.

Example 25 - Alkylation of Crosslinked Polydiallylamine with (3-chloropropyl) dimethyldodecylammonium bromide

A mixture of 5 g of the crosslinked polymer gel of Example 23 and 28 g (3-chloropropyl)dimethyl-dodecylammonium bromide was dispersed in 150 mL deionized water and the suspension was stirred. To this suspension 2 g 50% NaOH was added and the mixture was stirred for 15 minutes. The mixture was then heated with stirring to 75° C. An additional 4 g 50% NaOH was added in 1 g batches at 1.5 hr intervals (the base addition was such as to maintain the pH between 10 to 12). After stirring at 75° C for a total period of 18 hr, the reaction mixture was allowed to cool. After cooling to 30° C, 2 mL concentrated HCl was added and the mixture was stirred for 30 minutes. The polymer particles were filtered off and washed with 200 mL methanol. The filtered polymer particles were suspended twice in methanol (400 mL) and the suspension was stirred for 40 minutes. This process was repeated. After removing the polymer by filtration, the polymer was suspended in 500 mL 2M NaCl solution and the suspension was stirred for 40 minutes. This NaCl treatment was repeated twice and the filtered polymer was suspended in 500 mL deionized waer. The mixture was stirred for an additional 45 minutes, filtered, resuspended in 400 mL deionized water and stirred for another 40 minutes. To this suspension, 1 mL concentrated HCl was added and the mixture was stirred for 20 minutes. The polymer was filtered off and dried in a forced air oven at 60° C, yielding 13.2 g of alkylated polymer as a light yellow solid which was ground and passed through a 140 mesh sieve.

Example 26 - Alkylation of Crosslinked Poly(diallylmethylamine) with 1-bromooctane

The 3% crosslinked poly(diallylmethylamine) of Example 6 (5 g) was taken in a 500 mL 3-necked round-bottomed flask and suspended in 110 mL deionized water. The polymer swelled significantly and was stirred with a mechanical stirrer. To this swollen gel, a solution of 11.1 g 1-bromooctane in 50 mL ethanol was added and the reaction mixture was stirred for 10 minutes. 1 g 50% aqueous sodium hydroxide was then added and the reaction mixture was stirred at room temperature for 40 minutes followed by

heating to 75° C for 1.5 hr. 1 g NaOH solution was added, and the reaction mixture was allowed to stir at 75° C for an additional 18 hr. After the mixture had cooled to 30° C, 2.5 mL concentrated HCl was added and the mixture was stirred for 30 minutes. The polymer was filtered and washed with 300 mL deionized water and 300 mL
5 methanol. Polymer particles were suspended in 300 mL methanol and the suspension was stirred for 40 minutes. After removing the polymer by filtration, the polymer was suspended in 300 mL 2 M NaCl solution and the suspension was stirred for 40 minutes. The polymer was filtered off and this NaCl treatment was repeated two more times. The filtered polymer cake was washed with 400 mL deionized water, then suspended in 400
10 mL deionized water. After the suspension was stirred for 30 minutes, it was filtered and the polymer was resuspended in 400 mL deionized water and this suspension was stirred for an additional 30 minutes. 1 mL concentrated HCl was added to the suspension, which was then stirred for 30 minutes. The polymer was filtered and dried at 60° C in a forced air oven, yielding 7.0g of the alkylated polymer as a pale white solid. The
15 polymer was ground and passed through a 140 mesh sieve.

Example 27 - Alkylation of Crosslinked Poly(diallylmethylamine) with
1-bromotetradecane

The 3% crosslinked poly(diallylmethylamine) of Example 6 (5 g) was taken in a 500 mL 3-necked round bottomed flask and suspended in 100 mL deionized water. The
20 polymer swelled significantly and was stirred with a mechanical stirrer. To this swollen gel, 16 g 1-bromotetradecane dissolved in 40 mL ethanol was added and the reaction mixture was stirred for 10 minutes. 1 g 50% aqueous sodium hydroxide was then added and the reaction mixture was stirred at room temperature for 40 minutes followed by heating to 75° C for 1.5 hr. 1 g NaOH solution was then added and the reaction mixture
25 was stirred at 75° C for additional 18 hr. After cooling to 30° C, 2.5 mL concentrated HCl was added and the mixture was stirred for 30 minutes. The polymer was filtered and washed with 300 mL deionized water and

300 mL methanol. Polymer particles were suspended in 300 mL methanol and the suspension was stirred for 40 minutes. After removing the polymer by filtration, the polymer was suspended in 300 mL 2M NaCl solution and the suspension was stirred for 40 minutes. The polymer was filtered off and this NaCl treatment was repeated two
5 more times. The filtered polymer cake was washed with 400 mL deionized water and suspended in 400 mL deionized water. After stirring for 30 minutes the suspension was filtered and the polymer was resuspended in 400 mL deionized water. This suspension was stirred for an additional 30 minutes. 1 mL concentrated HCl was then added to the suspension and stirring continued for 30 minutes. The polymer was filtered off and
10 dried at 60° C in a forced air oven, yielding 9.0 g of the alkylated polymer as a pale white solid. The polymer was ground and passed through a 140 mesh sieve.

Example 28 - Alkylation of Crosslinked Poly(diallylmethylamine) with
(3-chloropropyl)dimethyloctadecylammonium bromide

(3-Chloropropyl)dimethyloctadecylammonium bromide was prepared by the
15 general method of Example 10 starting with dimethyloctadecylamine. A mixture of the crosslinked polymer gel of Example 6 and 35 g (3-chloropropyl)dimethyloctadecyl-
ammonium bromide was dispersed in 150 mL deionized water and the mixture was heated to 70° C with stirring for 15 minutes. 2 g 50% aqueous solution of NaOH and 50
mL ethanol were then added to the reaction mixture. After 2 hr, 0.5 g NaOH solution
20 was added and the reaction mixture was stirred at 70° C for 20 hr. When the reaction mixture had cooled to 30° C, 2mL concentrated HCl was added and the mixture was stirred for another 20 minutes. The polymer was filtered off and washed with 200 mL deionized water and 200 mL methanol. The filtered polymer particles were dispersed in
500 mL methanol, stirred for another 30 minutes and then filtered. This process was
25 repeated one more time and the filtered polymer was suspended in
300 mL 2M NaCl solution. The resulting suspension was stirred for another 45 minutes and filtered. After repeating the NaCl treatment twice, the filtered polymer was suspended in 400 mL deionized water. The mixture was stirred for 30 minutes, filtered,

and the polymer was resuspended in 400 mL deionized water. The suspension was stirred for an additional 40 minutes. To this suspension was added 1 mL concentrated HCl and the mixture was stirred for 20 minutes. The polymer was filtered and dried in a forced air oven at 60° C, yielding 10.7 g alkylated polymer as a pale white solid which
5 was ground and passed through a 140 mesh sieve.

Example 29 - Alkylation of Crosslinked Poly(diallylmethylamine) with
(3-Chloropropyl)dodecylpyrrolidiniumammonium bromide

Synthesis of (3-chloropropyl)dodecylpyrrolidinium bromide

47 g pyrrolidine, 149.5 g 1-bromododecane and 83 g potassium carbonate were
10 added to 560 mL acetone. The reaction mixture was heated at 55° C for 24 hr, then filtered. Solvent was removed from the filtrate, yielding 92 g N-dodecylpyrrolidine. 80 g N-dodecylpyrrolidine and 52.6 g 1-bromo-3-chloropropane were dissolved in 133 mL methanol and the reaction mixture was heated at 65° C for 18 hr. After cooling to room temperature, methanol was removed under reduced pressure. The residue was
15 poured into 2 L diethylether with stirring and the mixture was allowed to stand for another 6 hr. The white precipitate thus formed was filtered and was dried at 40° C under a vacuum for 24 hr yielding 85 g (3-chloropropyl)dodecylpyrrolidinium bromide as a white solid.

Alkylation of crosslinked poly(diallylmethylamine) with (3-chloropropyl)
20 dodecylpyrrolidinium bromide

The 3% crosslinked poly(diallylmethylamine) of Example 7 (5 g) and 30 g (3-chloropropyl)dodecyl-pyrrolidinium bromide were dispersed in 150 mL deionized water and the mixture was heated to 70° C with stirring. After stirring at 70° C for 15 minutes, 2 g 50% aqueous NaOH solution was added to the reaction mixture. After 2
25 hr, 1 g NaOH solution was added and the reaction mixture was allowed to stir at 70° C for 20 hr. The reaction mixture was then allowed to cool to 30° C.

2 mL concentrated HCl was then added and the mixture was stirred for 20 minutes. The polymer was filtered off and washed with 200 mL deionized water and 200 mL methanol. The polymer particles were dispersed in 500 mL methanol and the suspension was stirred for 30 minutes and then filtered. This process was repeated one
5 more time and the filtered polymer was suspended in 300 mL 2M NaCl solution. The resulting suspension was stirred for 45 minutes and filtered. After repeating this NaCl treatment twice, the filtered polymer was suspended in 400 mL deionized water. The mixture was stirred for 30 minutes, filtered, resuspended in 400 mL deionized water and stirred for an additional 40 minutes. To this polymer suspension was added 1 mL
10 concentrated HCl and stirring continued for an additional 20 minutes. The polymer was filtered off and dried in a forced air oven at 60° C, yielding 13 g alkylated polymer as a pale white solid which was ground and passed through a 140 mesh sieve.

Example 30 - Alkylation of Crosslinked Poly(diallylmethylamine) with (3-Chloropropyl)dodecylpiperidinium bromide

15 Synthesis of (3-chloropropyl)decylpiperidinium bromide

N-decylpiperidine was synthesized by reacting 45.7 g piperidine with 118.7 g 1-bromodecane in 237 mL acetone in the presence of 74 g potassium carbonate. After refluxing this reaction mixture at 55° C for 24 hr, it was filtered and acetone was removed from the filtrate to yield 61 g N-decylpiperidine. 5 g N-decylpiperidine and
20 42 g 1-bromo-3-chloropropane were dissolved in 50 mL methanol and the reaction mixture was heated at 65° C for 18 hr. After cooling to room temperature, methanol was removed under reduced pressure. The residue was poured into 2 L *tert*.butylmethyl ether with stirring and then the mixture was allowed to stand for 6 hr. The white precipitate thus formed was filtered and was dried at 40° C under vacuum for 24 hr
25 yielding 68 g (3-chloropropyl)decylpiperidinium bromide as a light yellow solid.

Alkylation of crosslinked poly(diallylmethylamine) with (3-chloropropyl) decylpiperidinium bromide

The 3% crosslinked poly(diallylmethylamine) of Example 6 (5 g) and 32 g (3-chloropropyl) decylpiperidiniumammonium bromide were dispersed in 150 mL deionized water and the reaction mixture was heated to 70° C with stirring for 15 minutes. 2 g 50% aqueous solution of NaOH was then added to the reaction mixture. After 2 hr, 1 g NaOH solution was added and the reaction mixture was allowed to stir at 70° C for 20 hr. When the reaction mixture had cooled to 30° C, 2 mL concentrated HCl was added and the mixture was stirred for 20 minutes. The polymer was filtered off and washed with 200 mL deionized water and 200 mL methanol. The polymer particles were dispersed in 500 mL methanol and the suspension was stirred for an additional 30 minutes, then filtered. This process was repeated once and the polymer was suspended in 300 mL 2M NaCl solution. The suspension was stirred for 45 minutes and filtered. After repeating this NaCl treatment twice, the filtered polymer was suspended in 400 mL deionized water. The mixture was stirred for 30 minutes, filtered, resuspended in 400 mL deionized water and the suspension was stirred for 40 minutes. To this polymer suspension was added 1 mL concentrated HCl and the mixture was stirred for 20 minutes. The polymer was filtered off and dried in a forced air oven at 60° C, yielding 13.2 g alkylated polymer as a pale white solid which was ground and passed through a 140 mesh sieve.

Example 31 - Alkylation of Crosslinked Poly(diallylmethylamine) with (4-Chlorobutyl)diethyldecylammonium bromide

(4-Chlorobutyl)diethyldecylammonium bromide was prepared by the general method of Example 10 using 4-chloro-1-bromobutane and decyldiethylamine. The 3% crosslinked poly(diallylmethylamine) of Example 6 (5 g) and 22 g (4-chlorobutyl) diethyldecylammonium bromide were dispersed in 150 mL deionized water and the resulting mixture was heated to 70° C with stirring for 15 minutes. 2 g 50 % aqueous solution of NaOH was then added to the reaction mixture. After 2 hr, 0.5 g NaOH

solution was added and the reaction mixture was allowed to stir at 70° C for 20 hr. When the reaction mixture had cooled to 30° C, 2 mL concentrated HCl was added and the mixture was stirred for an additional 20 minutes. The polymer was filtered off and washed with 200 mL deionized water and 200 mL methanol. The polymer particles
5 were dispersed in 500 mL methanol and the suspension was stirred for 30 minutes and then filtered. This process was repeated once and the filtered polymer was suspended in 300 mL 2M NaCl solution. The suspension was stirred for an additional 45 minutes and filtered. After repeating this NaCl treatment twice, the filtered polymer was suspended in 400 mL deionized water and the mixture was stirred for an additional 40 minutes. To
10 this polymer suspension was added 1 mL concentrated HCl and the mixture was stirred for 20 minutes. The polymer was filtered off and dried in a forced air oven at 60° C, yielding 10.6 g alkylated polymer as a pale white solid which was ground and passed through a 140 mesh sieve.

Example 32 - Alkylation of Crosslinked Poly(diallylmethylamine) with Varying
15 Amounts of (3-Chloropropyl)dimethyl-dodecylammonium bromide

This example illustrates alkylation of the 3% crosslinked poly(diallylmethylamine) of Example 6 with different amounts of (3-chloropropyl)dimethyldodecylammonium bromide. For this purpose, the polymer was treated with varying mole fractions of the alkylating agent (1.0, 0.75, 0.50, 0.25 and 0.10) via the general
20 procedure described in Example 9. Table 2 summarizes amounts of (3-chloropropyl)dimethyldodecylammonium bromide used to obtain polymers of varying degree of alkylation and yield of alkylated polymer per gram of the 3% crosslinked poly(diallylmethylamine). This g/g yield is a measure of the degree of alkylation of the polymer.

Table 2. Results of the alkylation of 3% crosslinked poly(diallylmethylamine) with varying amounts of (3-chloropropyl)dimethyldodecylammonium bromide ($C_{12}QC_3C_1Br$).

5	Polymer used (g)	Alkylating agent used (g)	Mole frctn of alkylating agent	Yield of alkylated	Yield (g/g)
	5.0	14.25	1.0	11.3	2.3
	5.0	10.7	0.75	8.3	1.7
	5.0	7.1	0.50	7.0	1.40
	5.0	3.6	0.25	6	1.20
10	5.0	1.40	0.10	5.1	1.02

Example 33 - Synthesis of 1,4-butanediol diglycidyl ether Crosslinked Poly(diallylmethylamine).

33.2 g the 60% solution of poly(diallylmethylamine) (PAS-M-1, Lot #51017) was diluted with 68 mL D.I. water. While stirring, 2.8 g NaOH was added to the polymer solution. The reaction mixture was allowed to stir until all NaOH had dissolved. When the temperature of the solution has dropped to below 30° C, 1.25 g 1,4-butanediol diglycidyl ether was added and stirring continued. The reaction medium slowly became increasingly viscous and after about 45 minutes it gelled and the stirring was stopped. The polymer gel was left at room temperature for an additional 48 hours.

The polymer slab was broken into smaller pieces and was dispersed in 300 mL D.I. water. The suspension was stirred for 30 minutes and was filtered. The swollen polymer particles were resuspended in 400 mL D.I. water, stirred for 1 hr and filtered. This process was repeated twice more. The filtered polymer (swollen gel) was dried in a forced air oven at 60° C to yield 15 g of the product.

Example 34 - Alkylation of 1,4-butanediol diglycidyl ether Crosslinked Poly(diallyl-methylamine) with 1-bromodecane

5 g of the ground polymer (Example 33) was placed in a 500 mL 3-necked round-bottomed flask was suspended in 100 mL D.I. water. The polymer swelled significantly and was stirred with a mechanical stirrer. To this swollen gel, 12 g 1-bromodecane dissolved in 100 mL ethanol was added and the reaction mixture stirred for 10 minutes. Subsequently, 1g 50% aqueous sodium hydroxide was added and the reaction mixture was stirred at room temperature for 40 minutes followed by an additional 0.5 g of NaOH solution after another 1.5 hr (the base addition was such as to maintain the pH between 10 and 12). The reaction mixture was allowed to stir at 75° C for an additional 18 hrs after which time heating was discontinued. After cooling to 30° C, 2 mL concentrated HCl was added and stirring for 30 minutes continued. The pH of the suspension dropped to 1.8. The polymer was filtered and washed with 250 mL D.I. water followed by 250 mL methanol. Polymer particles were suspended in 300 mL methanol and stirred for 40 minutes. After removing the solvent by filtration, the polymer was suspended in 250 mL 2M NaCl solution and stirred for an additional 40 minutes. It was filtered and this process of NaCl treatment was repeated two more times. The filtered polymer cake was washed with 250 mL D.I. water and suspended in 250 mL D.I. water. After stirring for 30 minutes it was filtered and resuspended in 400 mL D.I. water and stirred for an additional 30 minutes. 2 mL conc. HCl was added to the suspension and stirred for another 15 minutes. The pH of the suspension was found to be 2.10. After stirring for an additional 20 minutes, the polymer was filtered and dried at 60° C in a forced air oven yielding 9 g of the alkylated polymer as a pale white solid. The polymer was ground and passed through a 140 mesh sieve.

Example 35 - Reaction of poly(diallylmethylamine) with (4-chlorobutyl) dimethyldodecyl ammonium bromide

A solution of poly(diallylmethylamine) hydro-chloride (8.38 g of a 60% polymer solution in water), NaOH (5.5 g of a 50% NaOH solution in water), deionized

water (150 mL) and (4-chlorobutyl)dimethyldodecyl ammonium bromide (26.2 g) was heated to 75°C for 24 hours. After cooling to room temperature, the mixture was filtered. The solid was washed on the funnel with deionized water (1.5 L). The solid was suspended again in 2 M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was suspended again in 2 M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was suspended again in 2 M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was washed on the funnel with deionized water (2.0 L). The solid was suspended in deionized water (1.0 L), and concentrated HCl (1.4 mL) was added to this suspension. After stirring 1 hour, this suspension was filtered. The material was dried in a forced air oven at 60°C for 24 hours to afford 19.1 g of product.

Example 36 - Reaction of poly(diallylmethylamine) with 1-bromodecane

To a solution of poly(diallylmethylamine) hydro-chloride (16.7 g of a 60% polymer solution in water), NaOH (5.5 g of a 50% NaOH solution in water), deionized water (100 mL), and ethyl alcohol (100 mL) was added 1-bromodecane (44.4 g). This solution was then heated to 75°C for 24 hours. After the first 2 hours of heating, NaOH (1.0 g of a 50% NaOH solution in water) was added. After cooling to room temperature, the mixture was evaporated on a rotary evaporator to remove the ethyl alcohol. Water (500 mL) was added to the mixture, and the mixture was filtered. The solid was washed on the funnel with deionized water (1.0 L). The solid was suspended in 2M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was suspended again in 2 M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was suspended again in 2 M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was washed on the funnel with deionized water (2.0 L). The solid was suspended in deionized water (1.0 L) and concentrated HCl (2.4 mL) was added to this suspension, and after stirring 1 hour, this suspension was filtered. The material was dried in a forced air oven at 60°C for 24 hours to afford 20.8 g of product.

Example 37

A suspension of the product from Example 36 (5.01 g), methyl alcohol (100 mL), iodomethane (7.4 mL), and NaOH (1.0 g of a 50% NaOH solution in water) was stirred at room temperature for 24 hours. After the first 7 hours of reaction, 5 iodomethane (7.4 mL) was added. After the 24 hour reaction period at room temperature, NaOH (1.0 g of a 50% NaOH solution in water) was added, and the mixture was heated to 50°C for 4 hours. After one hour of heating, NaOH was added (1.0 g of a 50% NaOH solution in water). After the first 2.5 hours of heating (0.5 g of a 50% NaOH solution in water), NaOH was again added. After cooling to room 10 temperature, methyl alcohol (100 mL) was added to the mixture, and the mixture was evaporated on a rotary evaporator to remove the methyl alcohol. The solid was suspended in 2M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was suspended again in 2M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was suspended again in 2M NaCl (1.0 L), stirred for 30 minutes, and then filtered. 15 The solid was washed on the funnel with deionized water (4.0 L). The solid was suspended in deionized water (1.0 L) and concentrated HCl (50 drops) was added to this suspension, and after stirring 30 minutes, this suspension was filtered. The material was dried in a forced air oven at 60°C to afford 5.2 g of product.

Example 38

20 A suspension of the product from Example 35 (5.01 g), methyl alcohol (100 mL), iodomethane (7.0 mL), and NaOH (1.0 g of a 50% NaOH solution in water) was stirred at room temperature for 24 hours. After 7 hours of reaction, iodomethane (7.0 mL) was added. Following a 24 hour reaction period at room temperature, NaOH (1.0 g of a 50% NaOH solution in water) was added, and the mixture was heated to 25 50°C for 4 hours. After the first hour of heating, NaOH was added (1.0 g of a 50% NaOH solution in water). After 2.5 hours of heating, NaOH was again added (0.5 g of a 50% NaOH solution in water). After cooling to room temperature, methyl alcohol (100 mL) was added to the mixture, and the mixture was evaporated on a rotary evaporator

to remove the methyl alcohol. The solid was suspended in 2M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was suspended again in 2M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was suspended again in 2M NaCl (1.0 L), stirred for 30 minutes, and then filtered. The solid was washed on the funnel
5 with deionized water (4.0 L). The solid was suspended in deionized water (1.0 L), and concentrated HCl (50 drops) was added to this suspension. After stirring 30 minutes, this suspension was filtered. The material was dried in a forced air oven at 60°C to afford 4.9 g of product.

Example 39 -*In vivo* testing

10 The polymers produced in Examples 35-37 were tested *in vivo*, using the following protocol. After a week of acclimation to the facility, the animals were transferred to special cages that separate urine and feces. They were given only water for a 24 hour period in order to synchronize their urge for food as a drug. The food was presented for a 72 hour period. Fecal material was collected for 63 hours, from the hour
15 9 to hour 72 post presentation. The fecal material was freeze-dried to eliminate water from the material. It was pulverized with an amalgamator to a uniform powder, and 1 g was placed in the extraction cell. A solution of 80% methanol 100 mMol NaOH was used as the extraction solvent. The extraction was accelerated by holding the sample and solvent at 100°C and 1500 psi for 5 minutes. The extraction was evaporated and
20 reconstituted in bovine calf serum. The concentration was multiplied by four times the volume of extract and expressed as the concentration per gram of feces.

It is clear from the results shown in Table 3 that these sequestrants are highly active *in vivo*, with efficacy far surpassing the commercial bile acid sequestrant cholestyramine.

Table 3. *In Vivo* Efficacy of Polymers of Examples 35-37

Polymer	Dose (Percent in Diet)	Bile Acid Excretion (μ mole/g feces above control)
None	0%	0
Cholestyramine	0.3%	1.7
	0.60%	4.8
	0.90%	6.3
	1.20%	7.5
Example 35	0.10%	1.40
Example 36	0.10%	3.7
Example 37	0.10%	2.5

Example 40

In a 5 mL three necked round bottom flask was taken 10 g of the crosslinked poly(diallylmethylamine) of Example 6. To this was added 200 mL of deionized water. While stirring, 2 g of 50% aqueous NaOH solution was added to this polymer suspension. After stirring for 15 minutes, 13.6 g of 1-chlorodecane was added and the reaction mixture was heated to 90°C with stirring. After 1.5 hr of heating, 1.0 g of reagent of the NaOH solution was added to the reaction mixture followed by an additional 0.5 g of the NaOH after another 2 hr. After stirring at 90°C for a total period of 18 hr, the reaction mixture was allowed to cool to room temperature. Concentrated HCl (5 mL) was added to the reaction mixture and stirred for 30 minutes. The polymer was filtered and was washed with 500 mL of methanol. The polymer particles were suspended in 1 L of methanol, stirred for 30 minutes and filtered. After repeating this methanol washing once more, the polymer particles were suspended in 1 L of deionized water. The suspension was stirred for 30 minutes and filtered. The polymer particles were resuspended in 1 L of deionized water and stirred for 15 minutes. To this suspension was added 3 mL of concentrated HCl and

the stirring continued for an additional 30 minutes. The particles were filtered and dried in a forced air oven at 60°C, yielding 16 g of the alkylated polymer as light yellowish solid. The polymer was ground and passed through a 140 mesh sieve.

Example 41

5 This Example illustrates the role of the reaction temperature during alkylation of crosslinked of poly(diallylmethylamine) with 1-chlorodecane. For this purpose, the alkylation reactions were carried out at 70°C, 80°C, 90° and 100°C. The amount of 1-chlorodecane used and the reaction time was kept unchanged for all the reactions. Yield of the alkylated polymer thus obtained at these reactions temperatures are summarized in
10 Table 4.

 In a 500 mL three necked round bottomed flask was taken 10 g of the crosslinked poly(diallylmethylamine) (Example 6). To this was added 200 mL of deionized water. While stirring, 2 g of 50% aqueous NaOH solution was added to this polymer suspension. After stirring for 15 minutes, 13.6 g of 1-chlorodecane was added and the reaction mixture
15 heated to the appropriate temperature with stirring. After 1.5 hr of heating, 1.0 g of reagent of the NaOH solution was added to the reaction mixture followed by an additional 0.5 g of the NaOH after another 2 hr. After stirring at the appropriate temperature for a total period of 18 hr, the reaction mixture was allowed to cool to room temperature. Concentrated HCl (5 mL) was added to the reaction mixture and stirred for 30 minutes. The polymer was
20 filtered and was washed with 500 mL of methanol. The polymer particles were suspended in 1 L of methanol, stirred for 30 minutes and filtered. After repeating this methanol washing once more, the polymer particles were suspended in 1 L of deionized water. The suspension was stirred for 30 minutes and filtered. The polymer particles were resuspended in 1 L of deionized water and stirred for 15 minutes. To this suspension was added 3 mL of
25 concentrated HCl and the stirring continued for an additional 30 minutes. The particles were filtered and dried in a forced air oven at 60°C. Yield of the alkylated polymers obtained at different reaction temperatures are summarized in Table 4. All the polymers were ground and passed through a 140 mesh sieve.

Table 4. Results on the role of the reaction temperature on the alkylation of 4.5% epichlorohydrin crosslinked poly(diallylmethylamine with 1-chlorodecane.

Polymer used (g)	1-Chlorodecane used (g)	Reaction Temperature (°C)	Product Yield (g)
10	13.6	70	11.6
10	13.6	80	13.5
10	13.6	90	16.0
10	13.6	100	17.0

Example 42

This Example illustrates the role of the amounts of the 1-chlorodecane used in the alkylation of 4.5% epichlorohydrin crosslinked poly(diallylmethylamine) to prepare polymers with different degrees of alkylation. For this purpose, the polymer was treated with varying mole fractions of 1-chlorodecane (1.0, 0.5 and 0.25). All alkylation reactions were carried out at 90°C for a period of 18 hr. Table 5 summarizes the amounts of 1-chlorodecane used to obtain polymers of varying degrees of alkylation and the yield of the corresponding alkylated polymers.

In a 500 mL three necked round bottomed flask was taken 10 g of the crosslinked poly(diallylmethylamine) (example 6). To this was added 200 mL of deionized water. While stirring, 2 g of 50% aqueous NaOH solution was added to this polymer suspension. After stirring for 15 minutes, appropriate amount of 1-chlorodecane was added and the reaction mixture heated to 90°C with stirring. After 1.5 hr of heating, 1.0 g of reagent of the NaOH solution was added to the reaction mixture followed by an additional 0.5 g of the NaOH after another 2 hr. After stirring at 90°C for a total period of 18 hr, the reaction mixture was allowed to cool to room temperature. Concentrated HCl (5 mL) was added to the reaction mixture and stirred for 30 minutes. The polymer was filtered and was washed

with 500 mL of methanol. The polymer particles were suspended in 1 L of methanol, stirred for 30 minutes and filtered. After repeating this methanol washing once more, the polymer particles were suspended in 1 L of deionized water. The suspension was stirred for 30 minutes and filtered. The polymer particles were resuspended in 1 L of deionized water and stirred for 15 minutes. To this suspension was stirred for 30 minutes. The particles were filtered and dried in a forced air oven at 60°C. Yield of the alkylated polymers obtained for different alkylation levels are summarized in Table 5. All the polymers were ground and passed through a 140 mesh sieve.

Table 5. Results of the alkylation of 4.5% epichlorohydrin crosslinked polydiallylmethyl-amine with varying amounts of 1-chlorodecane.

Polymer used (g)	1-Chlorodecane used (g)	Reaction Temperature (°C)	Product Yield (g)
10	3.4	90	12.2
10	6.8	90	14.5
10	10.2	90	15.7
10	13.6	90	16.0

Example 43

Non-crosslinked Polydiallylamine hydrochloride (PDA-HCl) and non-crosslinked Poly(diallylmethylamine) hydrochloride (PDMA-HCl) were reacted with a variety of crosslinking agents and alkylating agents. Table 6 gives details of the crosslinking and alkylating agents, reaction conditions and yields (IPA = isopropyl alcohol; PDA=poly(diallylamine), PDMA=poly(diallylmethylamine)). The reactions conditions are analogous to those described in Example 42 where crosslinked poly(diallylmethylamine) was reacted with 1-chlorodecane.

Table 6

Example	Reactants (amount)	Solvent (amount)	Temperature	Time (hr)	Yield	
43	PDMA·HCl (100.0 g of 60% ag soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (600) mL	75°C	18	88	
44	PDMA·HCl (100.0 g of 60% aq soln), 1-bromodecane (62.9 g), 1,6-dibromohexane (9.37 mL), NaOH (5 addns of 6.5 g of 50% aq soln)	IPA (100 mL) H ₂ O (500 mL)	75°C	18	99	
5	45	PDMA·HCl (100.0 g of 60% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (32.5 g of 50% ag soln)	IPA (100 mL) H ₂ O (500 mL)	75°C	18	92
46	PDA·HCl (103.7 g of 52.3% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (7 addns for a total of 45 g of 50% aq soln)	IPA (100 mL) H ₂ O (100 mL)	75°C	18	53	
47	PDA·HCl (103.7 g of 52.3% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (90 g of 50% aq soln)	IPA (100 mL)	75°C	18	67	
48	PDA·HCl (103.7 g of 52.3% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (4 addns of 13.8 g of 50% aq soln)	IPA (100 mL)	75°C	18	62	
49	PDA·HCl (103.7 g of 52.3% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (135.0 g of 50% ag soln)	IPA (100 mL) H ₂ O (100 mL)	75°C	18	64	
10	50	PDA·HCl (92.0 g of 59% aq soln), 1-bromodecane (62.9 g), 1,6-dibromohexane (9.37 mL), NaOH (90.0 g of 50% aq soln)	IPA (100 mL) H ₂ O (100 mL)	75°C	18	90
51	PDA·HCl (95.3 g of 57% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), HaOH (90 g of 50% aq soln)	IPA (100 mL) H ₂ O (100 mL)	75°C	18	52	

Example	Reactants (amount)	Solvent (amount)	Temperature	Time (hr)	Yield
52	PDA·HC1 (92.0 g of 57% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (90 g of 50% aq soln)	IPA (100 mL) H ₂ O (100 mL)	75°C	18	87
53	PDA·HC1 (92.0 g of 57% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (6.35 mL), NaOH (90.0 g of 50% aq soln)	IPA (100 mL) H ₂ O (100 mL)	75°C	18	60
54	PDA·HC1 (95.6 g of 56.8% aq soln), 1-bromodecane (62.9 g), 1,6-dibromohexane (3.12 mL), NaOH (90.0 g of 50% aq soln)	IPA (100 mL) H ₂ O (100 mL)	75°C	18	71
55	PDA·HC1 (95.6 g of 56.8% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (1.59 mL), NaOH (90 g of 50% aq soln)	IPA (100 mL) H ₂ O (100 mL)	75°C	18	73
56	PDA·HC1 (54.3 g of 59% aq soln), 1-chlorodecane (50.2 g), epichlorohydrin (1.59 mL), NaOH (90 g of 50% aq soln)	H ₂ O (200 mL)	95°C	18	58
57	PDA·HC1 (100.0 g of 60% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL) NaOH (32.5 g of 50% aq soln)	H ₂ O (300 mL) IPA (300 mL)	75°C	18	86
58	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (32.5 g of 50% aq soln)	IPA (600 mL)	75°C	18	85
59	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (0.318 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (600 mL)	75°C	18	86
60	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromodecane (31.5 g), epichlorohydrin (4.77 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (600 mL)	75°C	18	74
61	PDMA·HC1 (100.0 g of 60% aq soln), 1,4-butanediol diglycidyl ether (11.74 mL), dodecyl/tetradecyl glycidyl ether (86.4 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (300 mL) IPA (300 mL)	75°C	18	11

Example	Reactants (amount)	Solvent (amount)	Temperature	Time (hr)	Yield
62	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromododecane (62.9 g), epichlorohydrin (9.54 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (300 mL) IPA (300 mL)	75°C	18	82
63	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromododecane (125.8 g), epichlorohydrin (4.77 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (300 mL) IPA (300 mL)	75°C	18	94
64	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (9.54 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (300 mL) IPA (300 mL)	75°C	18	81
65	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromodecane (118.0 mL), epichlorohydrin (4.77 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (300 mL) IPA (300 mL)	75°C	18	91
5 66	PDMA·HC1 (100.0 g of 50% aq soln), 1-bromododecane (35.8 g), epichlorohydrin (9.54 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (300 mL) IPA (300 mL)	75°C	18	66
67	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromododecane (80.7 g), epichlorohydrin (1.59mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (300 mL) IPA (300 mL)	75°C	18	90
68	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (600 mL) hexanes (1200 mL)	60°C	18	39
69	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (32.5 g of 50% aq soln)	toluene (600 mL)	75°C	18	60
70	PDMA·HC1 (100.0 g of 60% aq soln), 1-bromodecane (62.9 g), epichlorohydrin (4.77 mL), NaOH (32.5 g of 50% aq soln)	MeOH (600 mL) hexanes (1200 mL)	60°C	18	49
10 71	PDMA·HC1 (100.0 g of 60% aq soln), 1-chlorodecane (50.3 g), epichlorohydrin (4.77 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (600 mL)	95°C	18	82

Example	Reactants (amount)	Solvent (amount)	Temperature	Time (hr)	Yield
72	PDMA·HCl (100.0 g of 60% aq soln), 1-chlorodecane (65.3 g), epichlorohydrin (1.43 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (600 mL)	95°C	18	75
73	PDMA·HCl (100.0 g of 60% aq soln), 1-chlorodecane (32.7 g), epichlorohydrin (1.43 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (600 mL)	95°C	18	66
74	PDMA·HCl (100.0 g of 60% aq soln), 1-chlorodecane (16.4 g), epichlorohydrin (1.43 mL), NaOH (32.5 g of 50% aq soln)	H ₂ O (600 mL)	95°C	18	59

While this invention has been particularly shown and described with references to preferred embodiments thereof, it will be understood by those skilled in the art that various changes in form and details may be made therein without departing from the spirit and scope of the invention as defined by the appended claims.